

June 25

# Work Order ID 83775

\*83775\*

Page 1

April-25-12 10:13:09 AM

Item ID: D350-591-312

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step, Long RH

Start Date: 25/04/2012 Start Qty: 5.00

\*5\*

Cust Item ID:

Required Date: 25/06/2012 Req'd Qty: 5.00

\*5\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/2012 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

110

0.00

\*110\*

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R Aluminum Rod

3-Grind End Plate flush

119125  
120854

MLJ 12-6-13  
(5)

5 φ 12.05.16

Ac  
12.05.23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Item ID: D350-591-312

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop **\*NS2\***

Start Date: 25/04/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 25/06/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*120\***

QC

Memo

0.00

Quality Control

5 0 26/06/05

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

5/17/06/05

5

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

5 7/6/12-6-5

W/O:			WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Cust Item ID:

Required Date: 25/06/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00

**\*190\***

QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

**\*200\***

QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

**\*210\***

HandFinish

Memo

0.00

Hand Finishing

W/O:			WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 25/06/2012 Req'd Qty: 5.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*220\***

Powdercoat

Powder Coating

Memo

START TIME:

11:30

0.00

OVEN TEMPERATURE:

320°F

FINISH TIME:

12:00

5X  
RHM-F  
12/06/12

230

Wing Walk as per dwg QSI005 4.4 Batch 121613 0.00

**\*230\***

HandFinish

Hand Finishing

Memo

0.00

5

12/06/12

240

QC3- Inspect Part Finish

0.00

**\*240\***

QC

Quality Control

Memo

0.00

5RH

12/06/13

W/O:			WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 25/06/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

250

Pick Kit

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

5 12/06/13 JB

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

QC

Memo

0.00

Quality Control

Subtotal

5

270

Packaging

0.00

**\*270\***

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPD350-591-312

Location: HALL

Rec B

5

12/4/15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

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Item Name: Heli-Access-Step, Long RH

Start Date: 25/04/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 25/06/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

**\*280\***

QC

Memo

0.00

Quality Control

12/6/18

MF  
12-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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April-25-12 10:13:14 AM

Page 1

Work Order ID: 83775

\*83775\*

Parent Item: D350-591-312

\*D350-591-312\*

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 5.00

Required Qty: 5.00

## Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D  
fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No			110	Each	20.0000	1	5			
*D3272-1*									**			12.05.23	
Step													

Location	Loc Qty	Loc Code
ST	383777	-10
WA		30
	81312	10
	81313	10

D3067-1

\*D3067-1\*

End Plate

Manufactured No

110

Each

187.0000

1

5

\*\*

12.05.23

Location	Loc Qty	Loc Code
WA		123
	78608	4
	80881	45
	81969	74
WA016		64
	67582	2
	68214	1
	79607	1
	83053	60

5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 83775

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

\*83775\*

\*D350-591-312\*

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 5.00

Required Qty: 5.00

D3219-1

Manufactured No

110

Each

323.0000

2

10

\*D3219-1\*

Plate

\*\*

12.05.23

## Location

## Loc Qty

## Loc Code

WA

84

82221

84

WA016

118

73410

12

77674

6

81292

80

82059

20

WA017

121

81971

121

10

D3066-1

Manufactured No

180

Each

101.0000

2

10

\*D3066-1\*

Spacer

\*\*

B83854 → 10

Ac 12.06.07

## Location

## Loc Qty

## Loc Code

WA

101

81968

101

MS20600-AD4W4

Purchased No

180

Each

3,044.000

16

80

\*MS20600-AD4W4\*

Rivets

\*\*

M118846 → 38

M121658 → 42

Ac 12.06.07

## Location

## Loc Qty

## Loc Code

ST321

3044

121011

9

121340

1035

121444

2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 83775

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

\*83775\*

\*D350-591-312\*

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 5.00

Required Qty: 5.00

D3065-041

Manufactured No

180

Each

19.0000

1

5

\*D3065-041\*

Step Leg Assembly Hi

\*\*

B83870 → 3

B80880 → 2

Ac 12.06.07

Location

Loc Qty

Loc Code

WA

19

66149

0

78798

18

79336

1

D3067-1

Manufactured No

180

Each

187.0000

1

5

\*D3067-1\*

End Plate

\*\*

12.06.08

Location

Loc Qty

Loc Code

WA

123

78608

4

80881

45

81969

74

WA016

64

67582

2

68214

1

79607

1

83053

60

AN3-35A

Purchased No

250

Each

127.0000

\*\*

121652

g b

12/06/13

\*AN3-35A\*

Bolt

Location

Loc Qty

Loc Code

ST353

127

120644

50

120717

50

121068

27

April-25-12 10:13:14 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-591-312

**\*D350-591-312\***

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 5.00

Required Qty: 5.00

D3235-1 Manufactured No

250 Each

39.0000

**\*D3235-1\***

Mounting Lug

\*\*

83311

JB

Location

Loc Qty

Loc Code

ST

39

78787

39

D3278-041 Manufactured No

250 Each

68.0000

**\*D3278-041\***

Support Assembly

\*\*

83856

JB

Location

Loc Qty

Loc Code

ST471

3

78795

3

ST481

65

82015

40

83361

25

AN960JD416 NAS1149D0463J Purchased No

250 Each

10.0000

**\*AN960JD416\***

Washer

\*\*

80

JB

Location

Loc Qty

Loc Code

ST351

10

116289

10

AN960JD516 NAS1149D0563J Purchased No

250 Each

0.0000

**\*AN960JD516\***

Washer

\*\*

121912

20

119246 JB

12/06/13

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 5.00

Required Qty: 5.00

AN5-36A

Purchased

No

250

Each

156.0000

2

10

\*\*

121652/B



\*AN5-36A\*

Bolt

Location

Loc Qty

Loc Code

340

100

121181

100

ST340

56

120187

6

120731

50

D2618

Manufactured

No

250

Each

190.0000

2

10

\*\*

83614/B



\*D2618\*

Bushing

Location

Loc Qty

Loc Code

ST012

190

76130

2

80474

188

D2230-3

Manufactured

No

250

Each

87.0000

4

20

\*\*

83261/B

12/06/13



\*D2230-3\*

Bug

Location

Loc Qty

Loc Code

ST480

87

53881

4

70973

1

81558

82

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Shop Packet Print

Page 5

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\*D350-591-312\*

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 5.00

Required Qty: 5.00

D2856-400

Manufactured No

250 f

335.5345 1.2 6

\*D2856-400\*

Abrasion Strip

\*\*

## Location

## Loc Qty

## Loc Code

ST403	216
81875	216
ST409	119.5345
63735	0.6696
68076	0.3149
71164	8.46
79551	110.09

81875

cut (2) D2856-400-720 as per dwg  
MS21042L3

Purchased No

250 Each

3,434.000

10

\*MS21042L3\*

Nut

\*\*

## Location

## Loc Qty

## Loc Code

ST300	3434
117441	16
117885	32
118451	5
118927	3
119017	1340
119075	158
121349	880
121444	1000

121349

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April-25-12 10:13:14 AM

Page 7

Work Order ID: 83775

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

\*83775\*

\*D350-591-312\*

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 5.00

Required Qty: 5.00

AN4-13A Purchased

No

250

Each

979.0000

8

40

\*\*

\*AN4-13A\*  
Bolt

## Location

## Loc Qty

## Loc Code

ST357

979

119449

39

120187

19

120422

21

120770

400

121162

500

MS21042L5

Purchased

No

250

Each

1,307.000

2

10

\*\*

\*MS21042L5\*  
Nut

## Location

## Loc Qty

## Loc Code

ST300

1307

116105

5

116548

43

117611

30

119109

1229

MS21042L4

Purchased

No

250

Each

5,814.000

8

40

\*\*

\*MS21042L4\*  
Nut

## Location

## Loc Qty

## Loc Code

ST300

5814

116188

5

119017

4

119075

805

121011

2000

121444

3000

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

20

\*\*

\*AN960JD10\*  
Washer

Shop Packet Print

April-25-12 10:13:14 AM

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005.4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005.4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

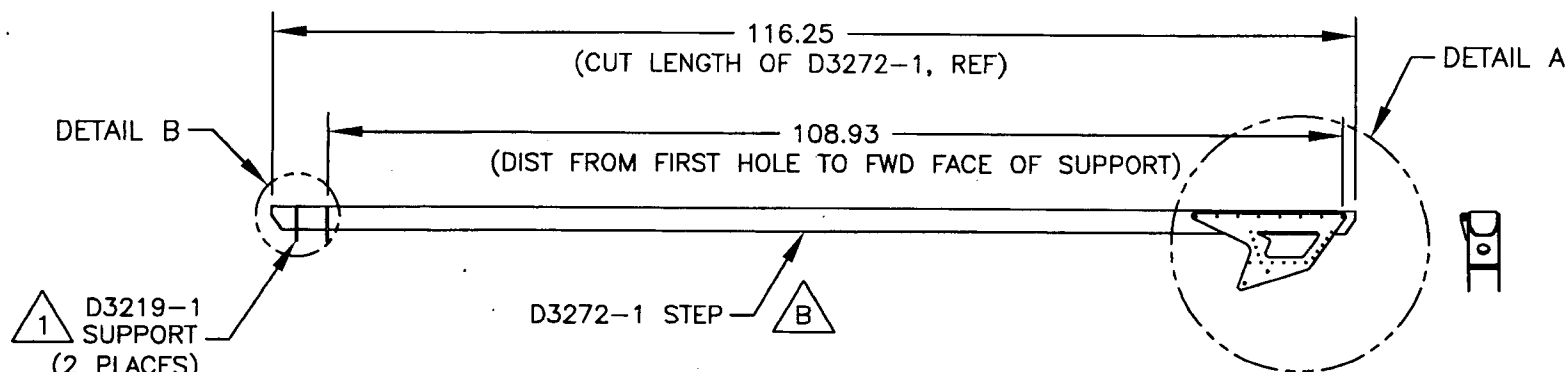
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83775 MCT  
12/07/24

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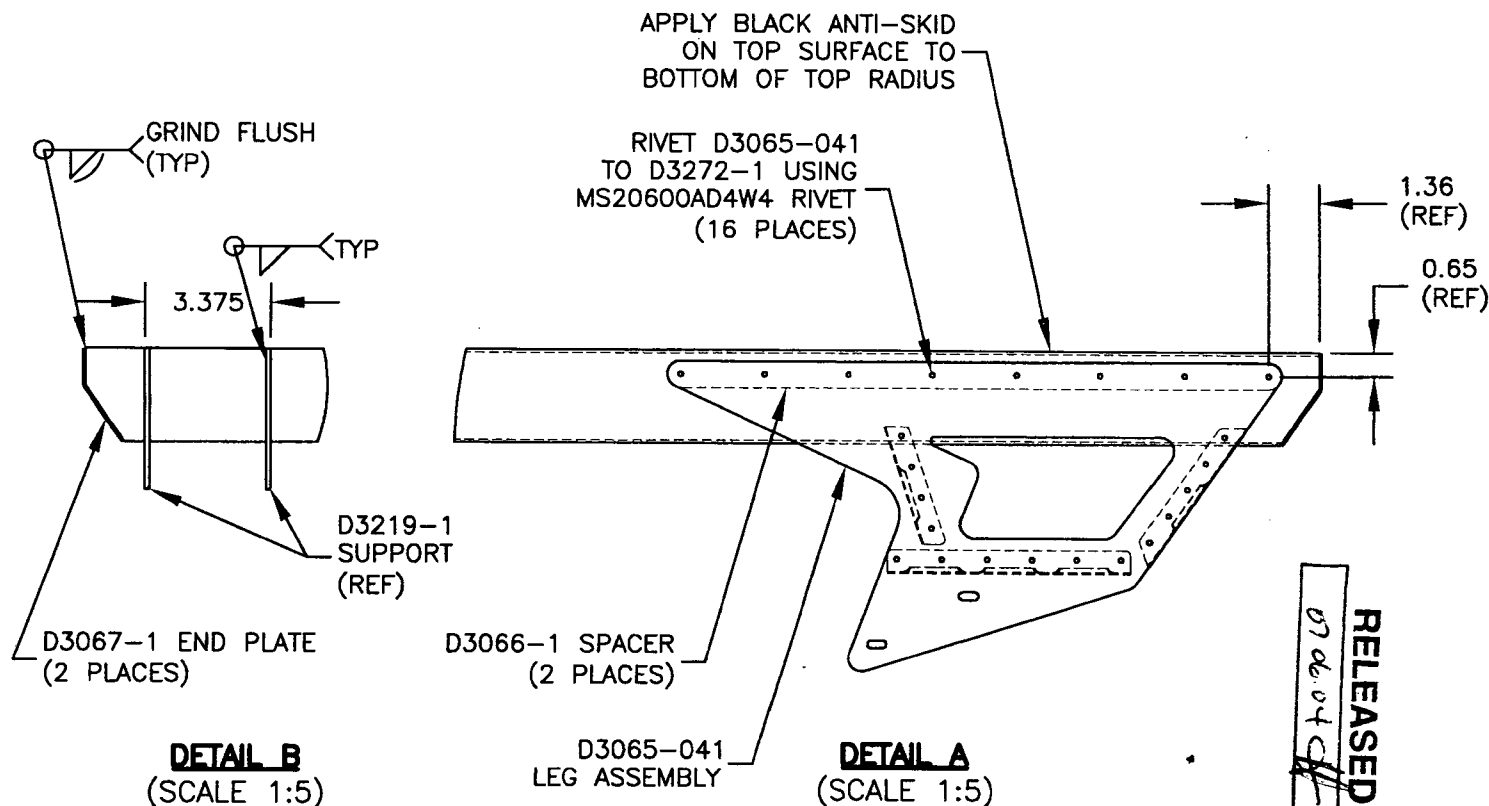
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03775

**DART**



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



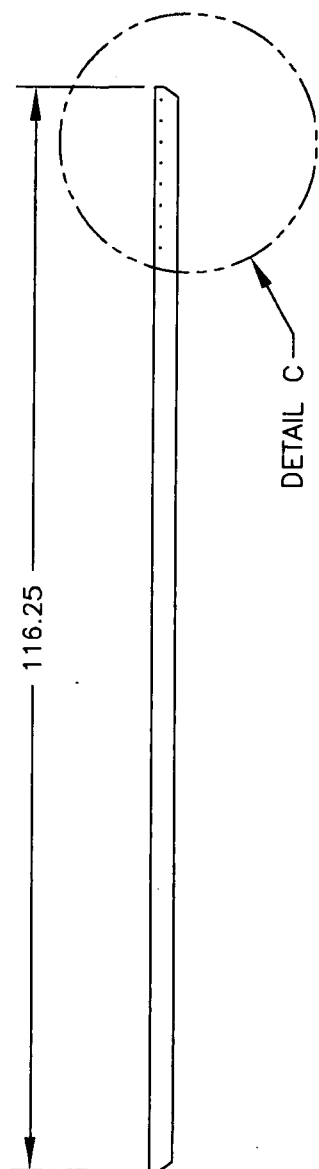
DESIGN	90	DRAWN BY		<b>DART AEROSPACE LTD</b>
CHECKED	LE	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE		1:20

DESIGN <i>qp</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

**DART**

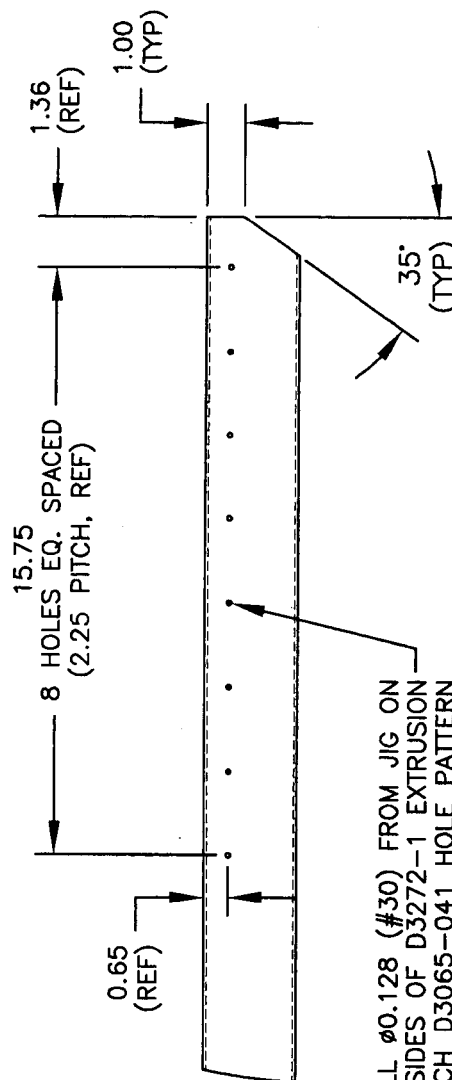
RELEASED

07.06.04 *[Signature]*



DETAIL C

**B D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN8-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.